

5/28

DART AEROSPACE LTD	Work Order:	23736
Description: Tube Detent Clip Base	Part Number:	D3440-9
Dwg: D3440 Rev. A page 4	Qty:	2
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.07.04	2
2	MV	Cut blank: 1.250" x 1.250" x 1.825" long Material: 6061-T6 Bar 1.250" x 1.250" (M6061T6B1.250x01.250) Identify for D3440-9	EN	05.07.05	2
		Batch: M11972			
3	MV	Machine as per Folio FA535 and Dwg D3440 Dwg Rev: <u>A</u> Identify as D3440-9	EN	05.07.05	2
		Folio Rev: <u>A</u>			
4	QC2	Inspect parts as they come off the CNC machine	EN	05.07.05	2
5	QC8	Second check	EC	05.07.05	2
6	MV	Deburr	EC	05.07.05	2
7	ST	Identify and Stock	EC	05.07.05	2
8	AC	Cost / part: 11.55	AG	05.07.06	2
9	DC	Close W/O 11.55 Inspect Level 21	HA	05.07.15	2

Rev	Date	Change	Revised By	Approved
A	05.06.30	New issue	KJ/JLM	

**ENGINEERING
APPROVAL**

RELEASED
05.06.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

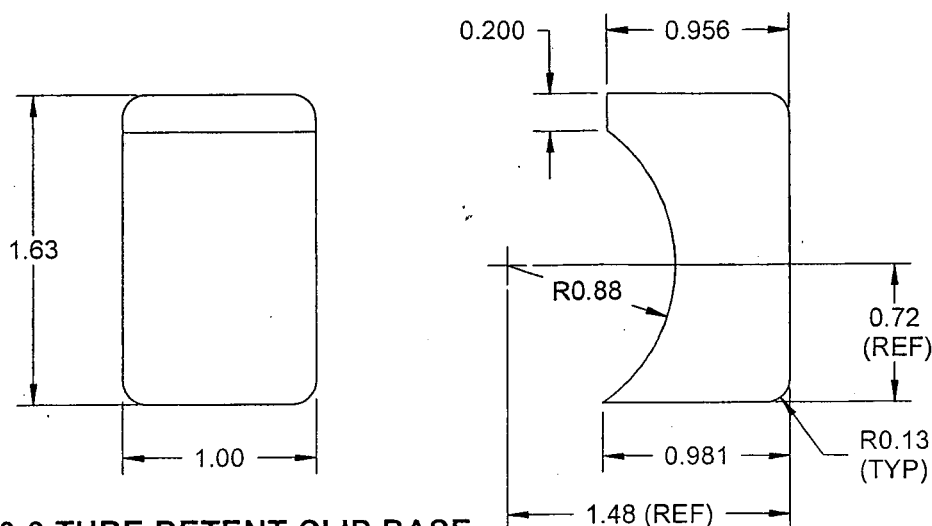
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

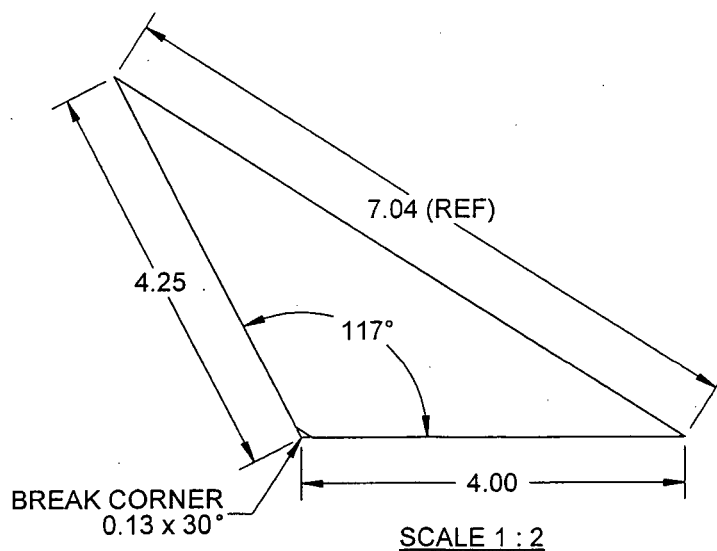
PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3440	REV. A SHEET 4 OF 4
DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-9 TUBE DETENT CLIP BASE
SUPERCED PREMIER P/N B67-43001-241

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)



D3440-11 GUSSET

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.250)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23736

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 04, 2005
10:18 am

Work Order No : 0023736
Project Name : D3440-9
Project For : WK528
Work Order Type : Main
Main WO Number :
House Part Number : D3440-9
Description : Tube Detent Clip Base
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 07-04-05
Est Finish Date : 07-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

